

# Work Order ID 69354

Tuesday, May 10, 2011 7:22:37 AM



Page 1

Item ID:	D3910-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Crosstube Lug					
Start Date:	5/10/2011	Start Qty:	20.00	Cust Item ID:		
Required Date:	5/18/2011	Req'd Qty:	20.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>CY</u>	Date:	<u>11/05/10</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	B								

100		0.00							
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut to 1.450" Long								

*Cut extension at meter*

110		0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA865 AND DWG								

FOLIO REV:  
DWG REV:

DEBURR

*issue 710 to meter*  
*machine as per drawing D3910*  
*Rev. B*

CY 11/05/10 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Required Date: 5/18/2011	Req'd Qty: 20.00		Customer:		

## Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 rec'd 	QC2-Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo	0.00							
	rec'd + inspect for transit damage attached CufC to W10								
130 	QC3-Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00							
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00							

Rec'd 5/10/25 (30)

S 4/10/25

QC20

30 BK 11-5-25.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 11/6/2011</i> Memo	0.00 0.00	<i>START: 8:00</i> <i>QWENT: 3:30</i> <i>FINISH: 8:30</i>			<i>30</i>		<i>BR 11-5-26</i>	
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				<i>30</i>		<i>φ M 11/05/26</i>	
170  Packaging Packaging	Identify as per dwg & Stock Location: <i>567</i>  Memo	0.00 0.00						<i>11/5/26</i>	<i>3028</i>

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Tuesday, May 10, 2011 7:22:37 AM



**Accept**

**Setup Start**

**Stop**



**Start Date:** 5/10/2011      **Start Qty:** 20.00

**Cust Item ID:**

**Required Date:** 5/18/2011      **Req'd Qty:** 20.00

**Customer:**

**Reference:**

Run Start



**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

**Tool ID**

**Tool #**Plan  
Code

Accept  
Qty

Reject  
QtyReject  
Number

**Insp.  
Stamp**

180

QC21- Final Inspection - Work Order Release

0.00



QC

## Memo

0.00

## Quality Control

11/5/30

440526





# Picklist Print

Tuesday, May 10, 2011 7:22:34 AM

Page 1

Work Order ID: 69354



Parent Item: D3910-3



Parent Item Name: Crosstube Lug

Start Date: 5/10/2011

Required Date: 5/18/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD  
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			100	f	233.6300	0.13	2.736842			
-------	--	--------------	----	--	--	-----	---	----------	------	----------	--	--	--



Lug Extrusion



CL 11/05/10

Location

Loc Qty

Loc Code

MAT006

233.63

43722

161.5

45800

1

63005

71.13

~~2.74~~ 3.9

D3910-3P

x30

PC 11/5/20 (30)

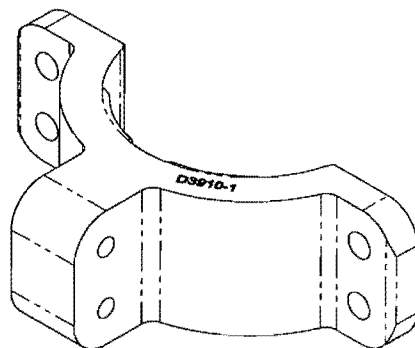
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

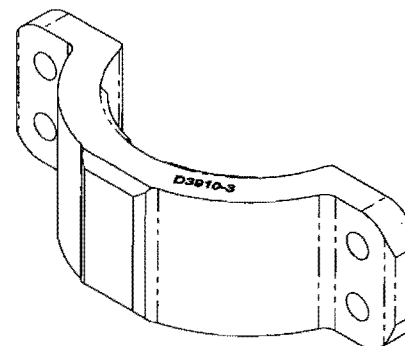
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3910-1 X-TUBE LUG**



**D3910-3 X-TUBE LUG**

CL 11105110  
W/O. 69354

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010  $\pm$  0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015  $\pm$  0.005
- 7) WEIGHT -1: 0.32 lbs  
-3: 0.25 lbs

**RELEASED**  
2010-03-22  
MP

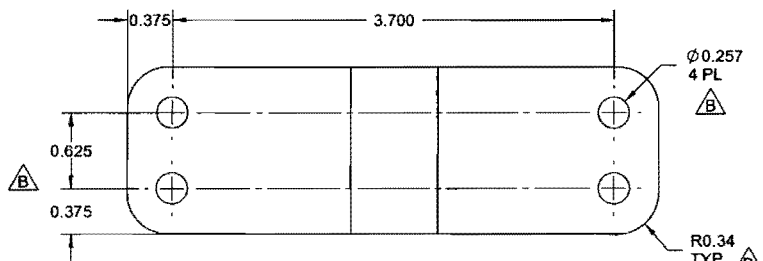
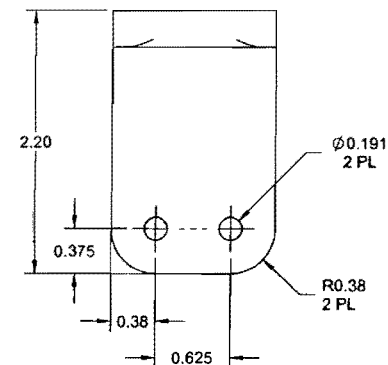
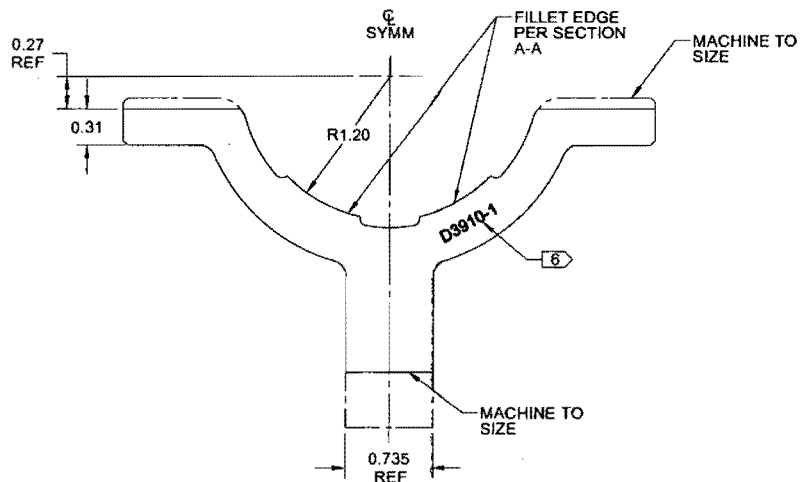
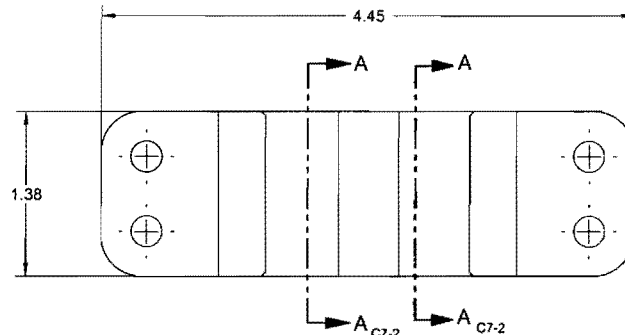
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3) REASON: SEE TR-D350-607-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3910	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		X-TUBE LUG (350)	NTS	
DATE	10.03.16		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





ROUND EDGE  
R0.06 MIN - R0.10 MAX  
2 PL

**SECTION A-A**  
C4-2  
C5-2



**D3910-1 X-TUBE LUG**

**RELEASED**  
2010-03-22

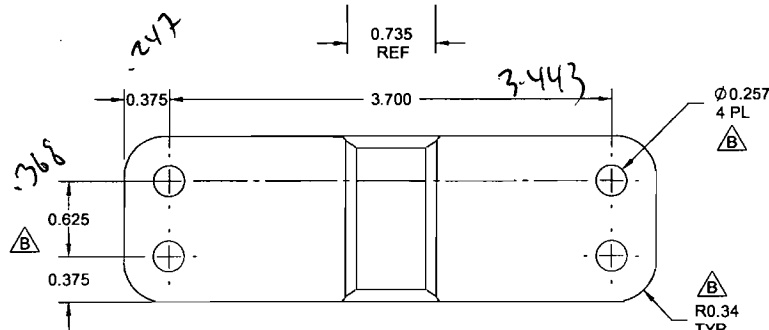
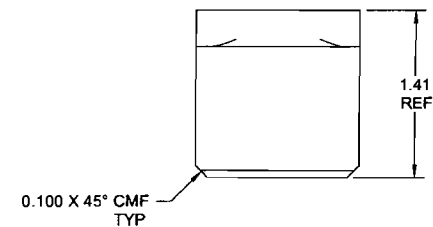
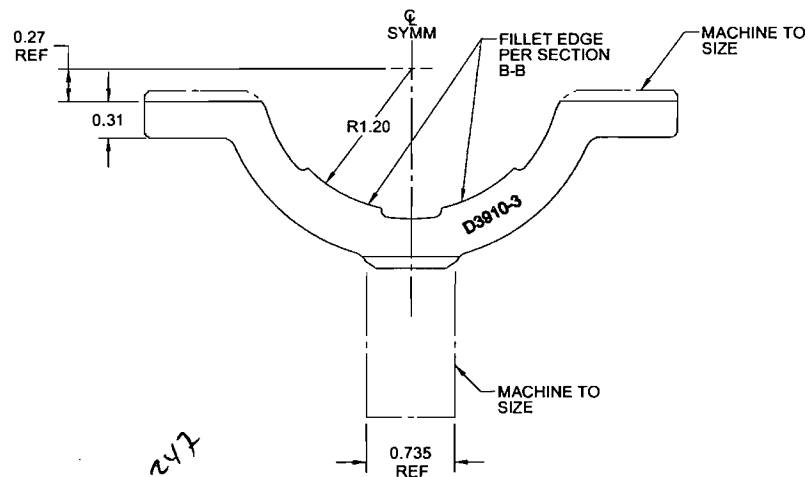
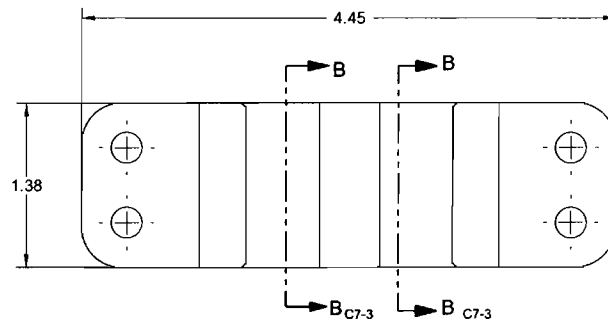
DESIGN	A/S	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 2 OF 3
APPROVED		TITLE	SCALE
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ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL

**SECTION B-B**  
C4-3  
C5-3



**D3910-3 X-TUBE LUG**

**RELEASED**  
2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. <b>D3910</b>	REV. B
MFG. APPR.		TITLE <b>X-TUBE LUG (350)</b>	SHEET 3 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.16		







Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO14043

Purchase Order Date 5/10/2011

PO Print Date 5/12/2011

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.  
20 TERRY FOX DRIVE PO BOX 781  
VANKLEEK HILL, QC K0B 1R0  
CA

Contact Name

Vendor Phone 613 678 3957

Vendor Fax 613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

REVISED  
QTY

Ship To :

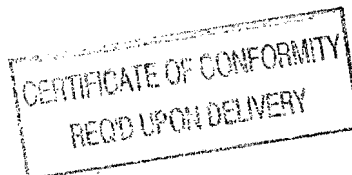
DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	D3910-3P	Crosstube Lug	5/18/2011 Yes	30.00 Each	Dart Truck	\$31.5500	\$946.50

Special Inst: MACHINE AS PER DWG D3910  
REV. B  
B69354

PO Total: \$946.50



Change Nbr: 2

Change Date: 5/12/2011

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable





20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0 , Canada  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 17987  
**Date:** May 24, 2011  
**Page:** 1

<b>Sold to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 140043	<b>Sold By:</b> Walz, Christian D.
<b>Shipped By:</b> your truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
3910-3 Crosstube Lug Material supplied by DART: D2423 B63005	Each	30	30	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

Received by \_\_\_\_\_

**Thank you for your order!**





## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

30

D3910-3

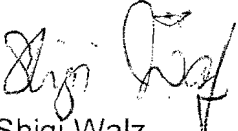
Crosstube Lug

14043

MATERIAL: supplied by DART D2423 B63005

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

Vankleek Hill, May 24, 2011

